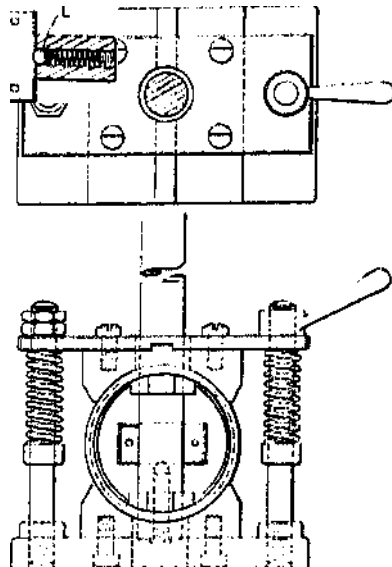


a pair of jaws bored to the proper size to fit the piston to be worked on. The springs on the upright studs hold up the upper or clamping jaw while the work is being put in or taken out.

In operation, a piston is slipped between the jaws, the facing bar run down through the cross-drilled holes, the cutter fitted into the bar, and the top jaw set by a half turn of the lever-handle nut. A feature of the facing bar is the manner in



LJ



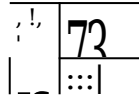


Fig. **£4.** Jig used for
Facing the Pifton

which the cutter is held. It will be swn that the cutter has a half-round notch in the center of the hot torn edge that registers with a steel ball *L* in the center of the cutter slot. A stiff spring holds the ball to its neat in the bar. The cutter is also provided with two holes near each end that arc used for pulling it out of the bar with, a stout wire hook. It is double edged, so that both bosses can be faced without reversing it or stopping the machine. This method of holding the cutter would not be desirable in the case of a boring tool, but for a facing tool it serves very well Of course* the cutler must IK* a nice fit in the